

152905

Monday, November 07, 2016 4:06:21 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

30

30

Customer:

Run Start *NR1*

Tooling:

Date:

QC: _____ Date: _____ SPC (Y/N): _____

SPC (Y/N):

Date:

NR2

Draw Nbr	Revision Nbr
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D3942	C
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DAS
46
9-89

16/11/09

0.00

100

Memo

0.10

1-Cut as per Dwg D3942-3

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

0.00

1 1 0

Memo

0.05

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 152905

Monday, November 07, 2016 4:06:21 PM

152905

Page 2

Item ID: D3942-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Clip

Stop

NS2

Start Date: 11/2/2016 Start Qty: 30.00

30

Cust Item ID:

Required Date: 11/7/2016 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.10							
Quality Control									
									DAS 38 9-89 NOV 10 2016
140	Identify as per dwg & Stock Location: <u>Stowed</u>	0.00							
140									
Packaging	Memo	0.05							
Packaging									
									30 DAS 9-89 NOV 09 2016
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.50							
Quality Control									
									16/11/10 JH

DAS
21
9-89

NOV 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, November 07, 2016 4:06:21 PM

Page 1

Work Order ID: 152905

152905

Parent Item: D3942-3

D3942-3

Parent Item Name: Clip

Start Date: 11/2/2016

Required Date: 11/7/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: Ipp Rev:A UPDATE TO REV B 10-11-24 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	229.1990	0.015	0.473684			

M304S18GA

304/316 .050 Sheet

**DAS
46
9-89**

16/11/09

Location

Loc Qty

Loc Code

MAT020

222.099

M133328

55.224

M133587

0.7

M134824

4.875

M135779

33.3

M136036

128

MAT20

7.1

M134580

7.1

O.S

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

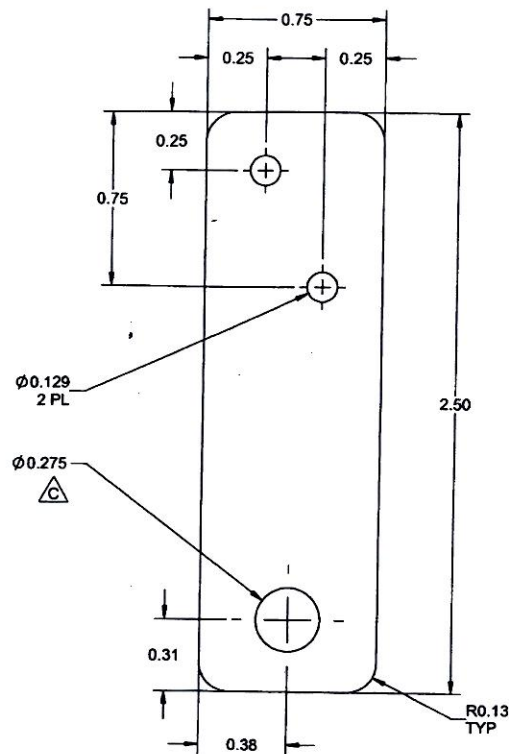
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Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																		
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																		
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																		
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																		
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
OTHER :																																																																					

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NO. 152905 MJS
16-11-09

0.050
REF

D3942-3 CLIP



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
18 GAUGE (0.050 THICK)
REF DART SPEC M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	XDF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3942	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.09.02	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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